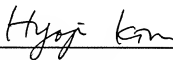


## Verification Statement For Translation

I, KIM, Hyo-Jin, hereby declare that I am conversant in the Korean and the English languages and that I am the translator of the document attached and certify that to the best of my knowledge and belief the following is a true and correct English translation of the specification contained in Korean Patent Application No. 10-2003-0003978.

Signature :



KIM, Hyo-Jin

Date :

October 15, 2007

## KOREAN INTELLECTUAL PROPERTY OFFICE

5

This is to certify that the following application annexed hereto is a true copy from the records of the Korean Intellectual Property Office.

10

Application No.: 10-2003-0003978

Filing date: January 21, 2003

Applicant(s): SAMSUNG SDI CO., LTD.

15

COMMISSIONER

(Translation)

## APPLICATION FOR PATENT

5      RECEIPT: The Commissioner of the Korean Intellectual Property Office

Filing date: January 21, 2003

10      TITLE: POSITIVE ELECTRODE FOR LITHIUM-SULFUR BATTERY AND LITHIUM-SULFUR BATTERY  
COMPRISING SAME

APPLICANT(S):

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GENERAL POWER OF ATTORNEY REGISTRATION NO.: 2001-041982-6

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30      The above identified application is duly submitted herewith pursuant to Article 42 of the Patent  
Act.

## ABSTRACT OF THE DISCLOSURE

### [Abstract]

5 The present invention relates to a positive electrode for a lithium-sulfur battery and a lithium-sulfur battery including the same, and the positive electrode includes a positive active material selected from elemental sulfur ( $S_8$ ), a sulfur-based compound and mixtures thereof; a conductive material; a binder; and an  $Al_2O_3$  additive with a particle size  $D(v, 50\%)$  of 35,000nm or less.

10 As described above, the positive electrode with the  $Al_2O_3$  additive with the critical particle size exhibits high ionic conductivity and decreased surface roughness, thereby increasing capacity from 1200mAh to 1289mAh, and improving cycle life from 60% to 91%.

### [Key words]

$Al_2O_3$ , Lithium sulfur battery, Positive electrode

[SPECIFICATION]

[TITLE OF THE INVENTION]

POSITIVE ELECTRODE FOR LITHIUM-SULFUR BATTERY AND LITHIUM-SULFUR  
BATTERY COMPRISING SAME

5 [DETAILED DESCRIPTION OF THE INVENTION]

[OBJECT OF THE INVENTION]

[FIELD OF THE INVENTION AND THE RELATED ART]

[Field of the Invention]

10 The present invention relates to a positive electrode for a lithium-sulfur battery and a lithium-sulfur battery comprising the same, and more particularly, to a positive electrode for a lithium-sulfur battery exhibiting good cycle life characteristics.

[Description of the Related Art]

15 The continued development of portable electronic devices has led to a corresponding increase in the demand for secondary batteries having both a lighter weight and a higher capacity. To satisfy these demands, the most promising approach is a lithium-sulfur battery with a positive electrode made of sulfur-based compounds.

20 Lithium-sulfur batteries use sulfur-based compounds with sulfur-sulfur bonds as a positive active material, and a lithium metal or a carbon-based compound which is one that can reversibly intercalate or deintercalate metal ions, such as lithium ions, as a negative active material. Upon discharging (i.e., electrochemical reduction), the sulfur-sulfur bonds are cleaved, resulting in a decrease in the oxidation number of sulfur (S), and upon recharging (i.e., electrochemical oxidation), the sulfur-sulfur bonds are re-formed, resulting in an increase in the oxidation number of the S, thereby generating the electrical energy and storing in the battery as chemical energy during charging, and is converted back to electrical energy during discharging.

25 With respect to specific density, the lithium-sulfur battery is the most attractive among the currently developing batteries since lithium has a specific capacity of 3,830 mAh/g, and sulfur has a specific capacity of 1,675 mAh/g. Further, the sulfur-based compounds are less costly than other materials, and they are environmentally friendly.

30 However, employing a positive electrode based on elemental sulfur in an alkali metal-sulfur battery system has been considered problematic. Although theoretically the reduction of sulfur to an alkali metal-sulfide confers a large specific energy, a very low percentage of utilization which indicates the amount of sulfur participated in the electrochemical redox reaction causes very low battery capacity.

Thus, there have been various studies to improve the electrochemical redox reaction and to increase capacity.

#### [SUMMARY OF THE INVENTION]

The present invention provides a positive electrode for a lithium-sulfur battery exhibiting good cycle life characteristic by controlling the roughness of the surface of the positive electrode using an additive with a critical particle size.

The present invention also provides a lithium-sulfur battery including the positive electrode.

#### [DETAILED DESCRIPTION OF THE INVENTION]

In one embodiment, the invention is directed to a positive electrode for a lithium-sulfur battery including a positive active material selected from elemental sulfur ( $S_8$ ), a sulfur-based compound, or a mixture thereof; a conductive material; a binder; and an  $Al_2O_3$  additive with a particle size D (v, 50%) of 35,000nm or less.

The present invention also provides a lithium-sulfur battery including the positive electrode including a positive active material selected from elemental sulfur ( $S_8$ ), a sulfur-based compound, or a mixture thereof; a conductive material; a binder; and an  $Al_2O_3$  additive with a particle size D (v, 50%) of 35,000nm or less, a negative electrode including a negative active material selected from a material that is capable of reversibly intercalating or deintercalating lithium ions, a material that reacts with lithium ions to prepare a lithium-included compound, a lithium metal, and a lithium alloy, and an electrolyte.

The present invention will be illustrated in more detail.

In one embodiment, the invention is directed to a positive electrode for a lithium-sulfur battery including a positive active material selected from elemental sulfur ( $S_8$ ), a sulfur-based compound, or a mixture thereof; a conductive material; a binder; and an  $Al_2O_3$  additive with a particle size D (v, 50%) of 35,000nm or less.

The present invention also provides a lithium-sulfur battery including the positive electrode including a positive active material selected from elemental sulfur ( $S_8$ ), a sulfur-based compound, or a mixture thereof; a conductive material; a binder; and an  $Al_2O_3$  additive with a particle size D (v, 50%) of 35,000nm or less, a negative electrode including a negative active material selected from a material that is capable of reversibly intercalating or deintercalating lithium ions, a material that reacts with lithium ions to prepare a lithium-included compound, a lithium metal, and a lithium alloy, and an electrolyte.

The present invention will be illustrated in more detail.

The present invention relates to a positive electrode for a lithium-sulfur battery including using an  $\text{Al}_2\text{O}_3$  additive with a desired particle size so that the positive electrode can provide batteries exhibiting good cycle life characteristics.

5 The positive electrode of the present invention includes the  $\text{Al}_2\text{O}_3$  additive with the particle size D (v, 50%) 55,000 nm or less, more preferably from 1 to 35,000 nm, even more preferably from 3 to 1,000 nm, and still more preferably from 5 to 5,000 nm. In this application, the term "particle size D (v, 50%)" means a particle size in which particles distributed with various size such as 0.1, 0.2, 0.3 .... 3, 5, 7, ....10, 20, or 30  $\mu\text{m}$  are accumulated to 50 volume %. As the particle size D (v, 50%) decreases, ionic conductivity increases so that a small particle size is preferable, and, if the particle size D (v, 50%) is more than 35000nm, the surface roughness ( $R_a$ ) of a produced positive electrode increases, making the surface of the positive electrode uneven, thereby deteriorating the capacity and particularly cycle life characteristics.

10 The particle size of the  $\text{Al}_2\text{O}_3$  additive may be controlled by a general mechanically mixing process such as a ball-milling process using a ball and a solvent for 1 to 24 hours. The solvent is any solvent that does not react with the metal oxide or metal sulfide, and useful solvents include isopropyl alcohol, ethyl alcohol, and methyl alcohol.

15 The  $\text{Al}_2\text{O}_3$  additive with the above particle size renders a decrease in the average surface roughness  $R_a$  of 5  $\mu\text{m}$ , preferably from 0.1 to 5  $\mu\text{m}$ , and more preferably 0.2 to 4  $\mu\text{m}$ , so that such a decreased surface roughness allows a decrease in interfacial resistance between a positive electrode and a separator, thereby decreasing internal resistance of batteries and providing good battery performance (capacity and cycle life).

20 The amount of the  $\text{Al}_2\text{O}_3$  additive is preferably 1 to 50 wt% based on the total amount of the positive active material, the conductive material, and the binder, more preferably 2 to 25 wt%, and most preferably 3 to 20 wt%. If the amount is less than 1 wt%, the effect by using the  $\text{Al}_2\text{O}_3$  additive cannot be realized, and if the amount

25 U. S. Patent Nos. 6,238,821, 6,406,814 and 6,210,831 disclose the use of  $\text{Al}_2\text{O}_3$  in a positive electrode. However, these patents are silent on control of the particle size of  $\text{Al}_2\text{O}_3$ , and thus, it is well understood to one in the related art that the battery performance improvement effect of the present invention by decreasing the internal resistance cannot be realized by these patents. Furthermore, U.S. Patent No. 5,474,858 discloses a positive electrode with an alumina drying agent. However, this is silent on the particle size of alumina. U.S. Patent No. 5,360,686 discloses alumina with a particle size of 0.5 micrometer. This

patent uses alumina in order to increase the mechanical strength of an electrolyte, but it is silent regarding alumina with a suitable particle size being capable of decreasing internal resistance of the battery.

The positive active material includes elemental sulfur ( $S_8$ ), a sulfur-based compound, or a mixture thereof. The sulfur-based compound may be selected from  $Li_2S_n$  ( $n \geq 1$ ), organic-sulfur compounds, and carbon-sulfur polymers ( $(C_2S_x)_n$ ;  $x = 2.5$  to  $50$ ,  $n \geq 2$ ).

The conductive material includes an electrically conductive material that facilitates the movement of electrons within the positive electrode and examples of the conductive material include, but are not limited to, conductive materials such as carbon (Trade mark: Super-P) or carbon black, or conductive polymers which include, but are not limited to, polyaniline, polythiophene, polyacetylene, polypyrrole, and the like, and the conductive material may be used alone or as a mixture of two or more of the above conductive materials.

A binder may be added to adhere the positive active material on a current collector. The binder may be poly(vinyl acetate), polyvinyl alcohol, polyethylene oxide, polyvinyl pyrrolidone, alkylated polyethylene oxide, crosslinked polyethylene oxide, polyvinyl ether, poly(methyl methacrylate), polyvinylidene fluoride, a copolymer of polyhexafluoropropylene and polyvinylidene fluoride (Trademark: KYNAR), polyethyl acrylate, polytetrafluoroethylene, polyvinyl chloride, polyacrylonitrile, polyvinyl pyridine, polystyrene, a derivative thereof, a blend thereof, or a copolymer thereof.

The positive electrode may further include a coating layer including a polymer, an inorganic material, or a mixture thereof.

The polymer may include polyvinylidene fluoride, a copolymer of polyvinylidene fluoride and hexafluoropropylene, poly(vinyl acetate), poly(vinyl butyral-co-vinyl alcohol-co-vinyl acetate), poly(methylmethacrylate-co-ethyl acrylate), polyacrylonitrile, polyvinyl chloride-co-vinyl acetate, polyvinyl alcohol, poly(1-vinylpyrrolidone-co-vinyl acetate), cellulose acetate, polyvinyl pyrrolidone, polyacrylate, polymethacrylate, polyolefin, polyurethane, polyvinyl ether, acrylonitrile-butadiene rubber, styrene-butadiene rubber, acrylonitrile-butadiene styrene, a sulfonated styrene/ethylene-butylene/styrene triblock copolymer, polyethylene oxide, or a mixture thereof.

Examples of inorganic material include colloidal silica, amorphous silica, surface-treated silica, colloidal alumina, amorphous alumina, tin oxide, titanium oxide, titanium sulfide ( $TiS_2$ ), vanadium oxide, zirconium oxide ( $ZrO_2$ ), iron oxide, iron sulfide ( $FeS$ ), iron titanate ( $FeTiO_3$ ), barium titanate ( $BaTiO_3$ ), and mixtures thereof. The organic material may be conductive carbon.



The positive electrode of the present invention is produced by the general procedure in which the positive active material, the conductive material, the binder, and the inventive  $\text{Al}_2\text{O}_3$  with a particle size  $D(v, 50\%)$  of 35,000nm or less are mixed in a solvent to prepare a composition (e. g. in the form of slurry), and the composition is coated on a current collector.

5 A lithium-sulfur battery of the present invention with the positive electrode includes a negative electrode and an electrolyte. The negative electrode of the lithium-sulfur battery includes a negative active material selected from materials in which lithium intercalation reversibly occurs, materials that react with lithium ions to form a lithium-containing compound, lithium metals, and lithium alloys.

10 The materials in which lithium intercalation reversibly occurs include carbon-based compounds, and any carbon-based compound may be used as long as it is capable of intercalating and deintercalating lithium ions, and examples of such carbon materials include crystalline carbon, amorphous carbon, and mixtures thereof. Examples of the material that reacts with lithium ions to form a lithium-containing compound include, but are not limited to, tin oxide ( $\text{SnO}_2$ ), titanium nitrate, and Si. The lithium alloys include alloys of lithium and a metal selected from Na, K, Rb, Cs, Fr, Be, Mg, Ca, Sr, Ba, Ra, Al, and Sn.

15 The negative electrode may include an inorganic protective layer, an organic protective layer, or a mixture thereof, on a surface of lithium metal. The inorganic protective layer includes Mg, Al, B, Sn, Pb, Cd, Si, In, Ga, lithium silicate, lithium borate, lithium phosphate, lithium phosphonitride, lithium silicosulfide, lithium borosulfide, lithium aluminosulfide, or lithium phosphosulfide. The organic protective layer includes a conductive monomer, oligomer, or polymer selected from poly(p-phenylene), polyacetylene, poly(p-phenylene vinylene), polyaniline, polypyrrole, polythiophene, poly(2,5-ethylene vinylene), acetylene, poly(perinaphthalene), polyacene, and poly(naphthalene-2,6-di-yl).

20 In addition, during charging and discharging of the lithium-sulfur battery, the positive active material (active sulfur) converts to an inactive material (inactive sulfur), which can be attached to the surface of the negative electrode. The term "inactive sulfur", as used herein, refers to sulfur that has no activity upon repeated electrochemical and chemical reactions so it cannot participate in an electrochemical reaction of the positive electrode, and the inactive sulfur on the surface of the negative electrode acts as a protective layer of the lithium negative electrode. Accordingly, inactive sulfur, for example lithium sulfide, on the surface of the negative electrode can be used in the negative electrode.

25 The electrolyte includes an electrolytic salt and an organic solvent.

The organic solvent may be a sole solvent or a mixed organic solvent with at least two components. The mixed organic solvent includes at least two groups selected from weak polar solvent groups, strong polar solvent groups, and lithium protection groups.

The term "weak polar solvent", as used herein, is defined as a solvent that is capable of dissolving elemental sulfur and has a dielectric coefficient of less than 15, and the weak polar solvent is selected from aryl compounds, bicyclic ether, and acyclic carbonate compounds. The term "strong polar solvent", as used herein, is defined as a solvent that is capable of dissolving lithium polysulfide and has a dielectric coefficient of more than 15, and the strong polar solvent is selected from bicyclic carbonate compounds, sulfoxide compounds, lactone compounds, ketone compounds, ester compounds, sulfate compounds, and sulfite compounds; and the term "lithium protection solvent", as used herein, is defined as a solvent that forms a good protective layer, i.e. a stable solid-electrolyte interface (SEI) layer, on a lithium surface, and which shows a cyclic efficiency of at least 50%, and the lithium protection solvent is selected from saturated ether compounds, unsaturated ether compounds, and heterocyclic compounds including N, O, and/or S.

Examples of the weak polar solvents include xylene, dimethoxyethane, 2-methyltetrahydrofuran, diethyl carbonate, dimethyl carbonate, toluene, dimethyl ether, diethyl ether, diglym, and tetraglyme.

Examples of the strong polar solvents include hexamethyl phosphoric triamide,  $\gamma$ -butyrolactone, acetonitrile, ethylene carbonate, propylene carbonate, N-methyl pyrrolidone, 3-methyl-2-oxazolidone, dimethyl formamide, sulfolane, dimethyl acetamide, dimethyl sulfoxide, dimethyl sulfate, ethylene glycol diacetate, dimethyl sulfite, and ethylene glycol sulfite.

Examples of the lithium protection solvents include tetrahydrofuran, 1,3-dioxolane, 3,5-dimethylisoxazole, 2,5-dimethyl furan, furan, 2-methyl furan, 1,4-oxane, and 4-methyldioxolane.

Examples of electrolyte salts include lithium trifluoromethane sulfonimide, lithium triflate, lithium perchlorate,  $\text{LiPF}_6$ ,  $\text{LiBF}_4$ , tetraalkylammonium salts, such as tetrabutylammonium tetrafluoroborate ( $\text{TBABF}_4$ ), liquid state salts at room temperature, e.g. imidazolium salts such as 1-ethyl-3-methylimidazolium Bis-(perfluoroethyl sulfonyl) imide ( $\text{EMIBetf}$ ), and combinations thereof.

The following examples illustrate the present invention in further detail. However it is understood that the present invention is not limited by these examples.

#### Example 1

$V_2O_5$  powder was pulverized in an isopropyl alcohol solvent with a zirconia ball for 3 hours, and the resulting material was dried at 80°C to prepare a  $V_2O_5$  additive with a particle size D (v, 50%) of 5,000 nm.

The  $V_2O_5$  additive, an elemental sulfur ( $S_8$ ) positive active material, a carbon conductive material, and a polyethyleneoxide binder were mixed in an acetonitrile solvent in the weight ratio of 1 : 6 : 2 : 2 with a ball to prepare a positive active material slurry. The elemental sulfur ( $S_8$ ) was obtained from pulverization with a zirconia ball in an isopropylalcohol solvent and drying, and it had a particle size D (v, 50%) of 5,000 nm.

The positive active material slurry was coated on a carbon-coated Al current collector to produce a positive electrode for a lithium-sulfur battery.

#### Example 2

A positive electrode was produced by the same procedure as in Example 1, except that the pulverization step was performed for 6 hours to prepare a  $V_2O_5$  additive with a particle size D (v, 50%) of 200 nm.

#### Example 3

A positive electrode was produced by the same procedure as in Example 1, except that the pulverization step was performed for 12 hours to prepare a  $V_2O_5$  additive with a particle size D (v, 50%) of 50 nm.

#### Example 4

A positive electrode was produced by the same procedure as in Example 1, except that the pulverization step was performed for 24 hours to prepare a  $V_2O_5$  additive with a particle size D (v, 50%) of 10 nm.

#### Example 5

A positive electrode was produced by the same procedure as in Example 1, except that the pulverization step was performed for 1 hour to prepare a  $V_2O_5$  additive with a particle size D (v, 50%) of 30,000 nm.

#### Example 6

A positive electrode was produced by the same procedure as in Example 1, except that the  $V_2O_5$  additive with a particle size D (v, 50%) of 150,000 nm without a pulverization step was used.

### Comparative Example 1

A positive electrode was produced by the same procedure as in Example 1, except that a  $V_2O_5$  additive was not used.

< Experiment 1: Measurement of ionic conductivity according to a particle size D (v, 50%) of  $V_2O_5$ >

Polyethylene oxide with a molecular weight of 5,000,000 was dissolved in acetonitrile, and a  $LiN(SO_2CF_3)_2$  lithium salt was added thereto and dissolved therein until the mole ratio of ethylene oxide to Li reached 10 : 1. The  $V_2O_5$  additive according to Examples 1 to 7 was added to the resulting solution in an amount of 10 wt% based on the total amount of polyethylene oxide and the  $LiN(SO_2CF_3)_2$  lithium salt, and they were shaken for 2 hours. The resulting solution was cast to form a polymer film, and the ionic conductivity thereof was measured. The results are presented in Table 1.

Table 1

Type of polymer film	Ionic conductivity (S/cm) (room temperature)
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub>	$9.6 \times 10^{-7}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (D(v, 50%)=150,000nm)	$1.0 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (D(v, 50%)=30,000nm)	$2.5 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (D(v, 50%)=5,000nm)	$4.5 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (D(v, 50%)=200nm)	$8.6 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (D(v, 50%)=50nm)	$3.0 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (D(v, 50%)=10nm)	$5.0 \times 10^{-5}$

As shown in Table 1, the addition of  $V_2O_5$  increased ionic conductivity, and such an increase in ionic conductivity is improved as the particle size of  $V_2O_5$  decreases. This believed to be because the inorganic additive such as  $V_2O_5$  prevents crystallization of the polymer.

Increases in ionic conductivity according to the amount of  $V_2O_5$  were measured. The  $V_2O_5$  with a particle size D (v, 50%) of 10 nm was used. The results are presented in Table 2.

Table 2

Type of polymer film	Ionic conductivity (S/cm)(room temperature)
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (2 wt%)	$1.0 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (5 wt%)	$4.0 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (10 wt%)	$5.0 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (15 wt%)	$3.5 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (20 wt%)	$2.0 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -V <sub>2</sub> O <sub>5</sub> (25 wt%)	$8.0 \times 10^{-6}$

It is evident from Table 2 that the amount of 5 to 15 wt% of V<sub>2</sub>O<sub>5</sub> exhibited higher ionic conductivity.

These two test results indicate that V<sub>2</sub>O<sub>5</sub> increases ionic conductivity, and as the particle size of V<sub>2</sub>O<sub>5</sub> decreases, ionic conductivity increases.

< Experiment 2: Measurement of surface roughness >

The surface roughness Ra of the positive electrodes according to Examples 1 to 6 and Comparative Example 1 were measured, and the results are shown in Table 3.

Table 3

	Composition of the positive electrode (weight ratio)	Surface roughness (Ra)
Comparative Example 1	Sulfur/Conductive material/Binder (6/2/2)	3.0
Example 6	Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=150,000nm) (6/2/2/1)	12.6
Example 5	Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=30,000nm) (6/2/2/1)	6.6
Example 1	Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=5,000nm) (6/2/2/1)	3.0
Example 2	Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=200nm) (6/2/2/1)	2.9
Example 3	Sulfur/Conductive material/Binder /V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=50nm) (6/2/2/1)	2.8
Example 4	Sulfur/Conductive material/Binder /V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=10nm) (6/2/2/1)	2.5

In Table 3, Ra indicates the arithmetic mean of each peak (between highest and lowest peaks), and the lower Ra indicates a more uniform surface. It is evident from Table 3 that Examples 5 and 6 with the particle size of V<sub>2</sub>O<sub>5</sub> larger than the sulfur active material (5,000 nm) exhibited poorer uniformity (unevenness and roughness) than Comparative Example 1 without

V<sub>2</sub>O<sub>5</sub>, and Examples 1 to 4 with a smaller or the same particle size of V<sub>2</sub>O<sub>5</sub> as the active material exhibited substantially the same or better uniformity.

#### < Experiment 3: SEM> Measurement

The lithium-sulfur cell using the positive electrode according to Example 1 was charged and discharged 10 times, and the cell was separated. Thereafter, a central portion from the positive electrode was sampled by the following procedure, and a SEM photograph of the central portion is shown in FIG. 2. The central portion was a portion corresponding to 60% thereof, with the exception of right and left 20% portions, when the total longitudinal direction length of the positive electrode is seen as 100%, as shown in FIG. 3. In addition, the central portion did not include the folded portion where the electrode was wound. The central portion was controlled to have a horizontal length of 1 to 5 cm, and a vertical length of 1 to 5 cm.

The central portion of the electrode was washed with a dimethoxyethane solvent for 10 seconds and then dried at 40°C for 24 hours.

In FIG. 2, the V<sub>2</sub>O<sub>5</sub> additive appeared in the form of oval particles rather than having a spherical shape. In this case, the particle size of the additive is determined as the longest cross-section of the oval, and is 5,000 nm or less. In the figure, most particles have a diameter of 1,000 nm or less. This is believed to be because of the use of the ball in the slurry preparation. If the ball is not used in the slurry preparation, it is expected that the particle size of the additive will be maintained.

#### < Experiment 4: Measurement of battery performance>

Using positive electrodes according to each of Examples 1 to 6 and Comparative Example 1, pouch-type lithium-sulfur cells were fabricated by the following procedure. The size of each positive electrode was 25mm X 50mm. The cells were test cells with a higher capacity than a coin cell (capacity of 3-5mAh).

A tab was welded to each positive electrode and the resulting positive electrode was placed in a pouch. On the positive electrode, a separator was positioned. A tab-attached lithium foil was placed on the separator, and the pouch was sealed except for at an electrolyte inserting hole. 1M LiN(SO<sub>2</sub>CF<sub>3</sub>)<sub>2</sub> in dimethoxyethane/1,3-dioxolane (80/20 volume ratio) was injected into the pouch.

The cell was charged at 0.2C and discharged at 0.5C, the 1<sup>st</sup> capacity and cycle life for 100<sup>th</sup> cycles were measured, and the results are presented in Table 4. In addition, internal resistance of the battery and surface roughness Ra of the positive electrode are shown in Table 4.

Table 4

	Surface roughness (Ra)	Internal resistance ( $\Omega$ )	1 <sup>st</sup> capacity (mAh/g)	Cycle life for 100th cycles (%)
Comparative Example 1	3.0	9.8	1200	60
Example 6	12.6	15.3	1053	55
Example 5	6.6	12.6	1125	58
Example 1	3.0	9.8	1215	76
Example 2	2.9	9.5	1230	85
Example 3	2.8	9.6	1250	88
Example 4	2.5	9.5	1280	90

It is shown in Table 4 that Examples 1 to 4 using  $V_2O_5$  with the same or smaller particle size than the sulfur positive active material (5,000 nm) exhibited lower surface roughness than Comparative Example 1 without  $V_2O_5$ . Such a lower surface roughness renders a decrease in interfacial resistance, causing a decrease in internal resistance of the battery and an increase in 1<sup>st</sup> capacity and cycle life.

On the other hand, Examples 5 and 6 using  $V_2O_5$  with a particle size larger than the sulfur positive active material (5,000 nm) exhibited greater surface roughness, which results in an increase in internal resistance and a decrease in capacity and cycle life.

Examples 7 to 11: Test for battery performance according to amount of added  $V_2O_5$

Positive electrodes were produced by the same procedure as in Example 1, except that amounts of  $V_2O_5$  with a particle size D (v, 50%) of 10 nm were changed as set forth in the following Table 5. The surface roughness of each positive electrode was measured, and the results are shown in Table 5. The result according to Example 4 with a particle size D (v, 50%) of 10 nm is also shown in Table 5.

Table 5

	Composition of positive electrode (weight ratio)	Surface roughness (Ra)
Comparative Example 1	Sulfur/Conductive material/Binder (60/20/20)	3.0
Example 7	Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=10nm) (60/20/20/2)	2.9
Example 8	Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=10nm) (60/20/20/5)	2.8
Example 4	Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=10nm) (60/20/20/10)	2.5
Example 9	Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=10nm) (60/20/20/15)	2.4
Example 10	Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=10nm) (60/20/20/20)	2.6
Example 11	Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (A: D(v, 50%)=10nm) (60/20/20/25)	2.5

Table 4 indicates that the same or smaller particle size of V<sub>2</sub>O<sub>5</sub> than the positive active material decreases surface roughness when compared with Comparative Example 1 without V<sub>2</sub>O<sub>5</sub>.

#### < Experiment 5: Measurement of Battery Performance >

Using positive electrodes according to each of Examples 4 and 7 to 11, pouch-type lithium sulfur cells were fabricated by the same procedure as in Experiment 4. The cells were charged at 0.2C and discharged at 0.5C, the 1<sup>st</sup> capacity and cycle life for the 100<sup>th</sup> cycles were measured, and the results are presented in Table 6. In addition, internal resistance of each battery and surface roughness Ra of each positive electrode are shown in Table 6.

Table 6

	Surface roughness (Ra)	Internal resistance ( $\Omega$ )	1 <sup>st</sup> capacity (mAh/g)	Cycle life for 100 <sup>th</sup> cycles (%)
Comparative Example 1	3.0	9.8	1200	60
Example 7	2.9	9.7	1220	70
Example 8	2.8	9.5	1245	88
Example 4	2.5	9.5	1280	90
Example 9	2.4	9.3	1254	84
Example 10	2.6	9.4	1234	82
Example 11	2.5	9.3	1230	72

It is shown in Table 6 that Examples 4 and 7 to 11 using V<sub>2</sub>O<sub>5</sub> with the same or smaller particle size than the sulfur positive active material (5,000 nm) exhibited lower surface



roughness than Comparative Example 1 without  $V_2O_5$ . Such a lower surface roughness renders a decrease in interfacial resistance, causing a decrease in internal resistance of the battery. As a result, the 1<sup>st</sup> capacities in Examples 4 and 7 to 11 are slightly larger than that in Comparative Example 1, and the cycle life greatly increased by 5 to 20% when compared with Comparative Example 1. This is believed to result from higher ionic conductivity in 5 to 20wt% of  $V_2O_5$ , even though Examples 4 and 7 to 11 have similar surface roughness (See Table 2).

As a result, the  $V_2O_5$  additive with the critical particle size increases ionic conductivity of the positive electrode and decreases surface roughness, thereby increasing capacity from 1200mAh to 1280mAh, and improving cycle life from 60% to 90%.

#### Experiment 6: Immersion of positive electrode in electrolyte

84 wt% of elemental sulfur ( $S_8$ ), 12 wt% of a carbon conductive material, and 4 wt% of a styrene butadiene rubber binder were mixed, and  $V_2O_5$  was added to the mixture in a water solvent to prepare positive active material slurries. The amounts of  $V_2O_5$  were 2, 5, 10, 15, 20, 25, and 30 parts by weight based on 100 parts by weight of the mixture.

The slurries were coated on carbon-coated Al current collectors. The coated collectors were dried at room temperature for 2 hours, then dried at 80°C for 12 hours to produce positive electrodes.

The positive electrodes were cut with a width of 2.5cm and a length of 5.0cm.

As shown in FIG.1, 90ml of dimethylethane and dioxolane electrolytic solvents were respectively poured into 100ml beakers, and 1cm ends of the cut positive electrodes were immersed in the electrolytic solvents in the beakers for 1 minute. The height, which indicates a degree to which the solvent is absorbed into the electrode and wicks up the electrode, was measured at room temperature under a normal atmosphere. The results are shown in Table 7.

Table 7

	Immersed height of dimethoxyethane (mm)	Immersed height of dioxolane (mm)
Sulfur/Conductive material/Binder (84/12/4)	2.0	1.0
Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (84/12/4/2)	2.5	2.0
Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (84/12/4/5)	4.0	3.0
Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (84/12/4/10)	6.0	3.5
Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (84/12/4/15)	8.0	6.0
Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (84/12/4/20)	8.5	6.0
Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (84/12/4/25)	8.5	6.0
Sulfur/Conductive material/Binder/V <sub>2</sub> O <sub>5</sub> (84/12/4/30)	8.6	6.0

The results from Table 7 are believed to come about because the porosity of the positive electrodes increases by the addition of V<sub>2</sub>O<sub>5</sub>, which results in better immersion of the electrolyte. It is believed that such a better immersion allows retention of electrolyte in the positive electrode during the charge and the discharge, and prevents damage to the negative electrode due to the electrolyte, thereby improving cycle life.

#### Example 12

A ZrO<sub>2</sub> additive with a particle size D (v, 50%) of 3,000 nm, an elemental sulfur (S<sub>8</sub>) positive active material, a carbon conductive material, and a polyethyleneoxide binder were mixed in an acetonitrile solvent in the weight ratio of 1 : 6 : 2 : 2 with a ball to prepare a positive active material slurry. The elemental sulfur (S<sub>8</sub>) was obtained from pulverization with a zirconia ball in an isopropylalcohol solvent and drying, and it had a particle size D (v, 50%) of 5,000 nm.

The positive active material slurry was coated on a carbon-coated Al current collector to produce a positive electrode for a lithium-sulfur battery.

### Example 13

ZrO<sub>2</sub> powder was pulverized in an isopropyl alcohol solvent with a zirconia ball for 1 hour, and the resulting material was dried at 80°C to prepare a ZrO<sub>2</sub> additive with a particle size D (v, 50%) of 2,000 nm.

The ZrO<sub>2</sub> additive, an elemental sulfur (S<sub>8</sub>) positive active material, a carbon conductive material, and a polyethyleneoxide binder were mixed in an acetonitrile solvent in the weight ratio of 1 : 6 : 2 : 2 with a ball to prepare a positive active material slurry. The elemental sulfur (S<sub>8</sub>) was obtained from pulverization with a zirconia ball in an isopropylalcohol solvent and drying, and it had a particle size D (v, 50%) of 5,000 nm.

The positive active material slurry was coated on a carbon-coated Al current collector to produce a positive electrode for a lithium-sulfur battery.

### Example 14

A positive electrode was produced by the same procedure as in Example 13, except that the pulverization step was performed for 6 hours to prepare a ZrO<sub>2</sub> additive with a particle size D (v, 50%) of 1,000 nm.

### Example 15

A positive electrode was produced by the same procedure as in Example 13, except that the pulverization step was performed for 12 hours to prepare a ZrO<sub>2</sub> additive with a particle size D (v, 50%) of 100 nm.

### Example 16

A positive electrode was produced by the same procedure as in Example 13, except that the pulverization step was performed for 24 hours to prepare a ZrO<sub>2</sub> additive with a particle size D (v, 50%) of 10 nm.

< Experiment 7: Measurement of ionic conductivity according to a particle size D (v, 50%) of ZrO<sub>2</sub>>

Polyethylene oxide with a molecular weight of 5,000,000 was dissolved in acetonitrile, and a LiN(SO<sub>2</sub>CF<sub>3</sub>)<sub>2</sub> lithium salt was added thereto and dissolved therein until the mole ratio of ethylene oxide to Li reached 10 : 1. The ZrO<sub>2</sub> additives according to Examples 10 to 14 were respectively added to the resulting solution in an amount of 10 wt% based on the total amount of polyethylene oxide and the LiN(SO<sub>2</sub>CF<sub>3</sub>)<sub>2</sub> lithium salt, and they were shaken for 2 hours. The resulting solutions were cast to form polymer films, and ionic conductivity thereof was measured. The results are presented in Table 8.

Table 8

Type of polymer film	Ionic conductivity (S/cm) (room temperature)
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub>	$9.6 \times 10^{-7}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (D(v, 50%)=3,000nm)	$1.1 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (D(v, 50%)=2,000nm)	$2.7 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (D(v, 50%)=1,000nm)	$8.9 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (D(v, 50%)=100nm)	$3.5 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (D(v, 50%)=10nm)	$5.1 \times 10^{-5}$

As shown in Table 8, the addition of ZrO<sub>2</sub> increases ionic conductivity, and such an increase in ionic conductivity is further improved as the particle size of ZrO<sub>2</sub> becomes smaller. This believed to come about because the inorganic additive such as ZrO<sub>2</sub> prevents crystallization of the polymer.

Increases in ionic conductivity according to the amount of ZrO<sub>2</sub> were measured. ZrO<sub>2</sub> with a particle size D (v, 50%) of 10 nm was used. The results are presented in Table 9.

Table 9

Type of polymer film	Ionic conductivity (S/cm)(room temperature)
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (2 wt%)	$1.2 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (5 wt%)	$4.2 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (10 wt%)	$5.1 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (15 wt%)	$3.3 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (20 wt%)	$2.1 \times 10^{-6}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -ZrO <sub>2</sub> (25 wt%)	$8.9 \times 10^{-6}$

It is evident from Table 9 that an amount of 5 to 15 wt% of ZrO<sub>2</sub> exhibited higher ionic conductivity.

These two test results indicate that ZrO<sub>2</sub> increases ionic conductivity and as the particle size of ZrO<sub>2</sub> decreases, ionic conductivity increases.

< Experiment 8: Measurement of surface roughness>

The surface roughness Ra of the positive electrodes according to Examples 12 to 16 and Comparative Example 1 were measured, and the results are shown in Table 10.

Table 10

	Composition of the positive electrode (weight ratio)	Surface roughness (Ra)
Comparative Example 1	Sulfur/Conductive material/Binder (6/2/2)	3.0
Example 12	Sulfur/Conductive material/Binder/ZrO <sub>2</sub> (A: D(v, 50%)=15000nm) (6/2/2/1)	2.9
Example 13	Sulfur/Conductive material/Binder/ZrO <sub>2</sub> (A: D(v, 50%)=30000nm) (6/2/2/1)	2.6
Example 14	Sulfur/Conductive material/Binder/ZrO <sub>2</sub> (A: D(v, 50%)=5000nm) (6/2/2/1)	2.5
Example 15	Sulfur/Conductive material/Binder/ZrO <sub>2</sub> (A: D(v, 50%)=200nm) (6/2/2/1)	2.4
Example 16	Sulfur/Conductive material/Binder /ZrO <sub>2</sub> (A: D(v, 50%)=50nm) (6/2/2/1)	2.3

In Table 10, Ra indicates the arithmetic mean of each peak (between highest and lowest peaks), and the lower Ra indicates a more uniform surface. It is evident from Table 10 that Comparative Example 1 without ZrO<sub>2</sub> exhibited poor uniformity (unevenness), whereas Examples 12 to 16 with ZrO<sub>2</sub> exhibited good uniformity.

#### < Experiment 9: Measurement of battery performance >

Using positive electrodes according to each of Examples 12 to 16 and Comparative Example 1, pouch-type lithium-sulfur cells were fabricated by the following procedure. The size of each positive electrode was 25mm X 50mm. The cells were test cells with a higher capacity than a coin cell (capacity of 3-5mAh).

A tab was welded to each positive electrode, and the resulting positive electrode was placed in a pouch. On the positive electrode, a separator was positioned. A tab-attached lithium foil was placed on the separator, and the pouch was sealed except for an electrolyte inserting hole. 1M LiN(SO<sub>2</sub>CF<sub>3</sub>)<sub>2</sub> in dimethoxyethane/1,3-dioxolane (80/20 volume ratio) was injected into the pouch.

Each cell was charged at 0.2C and discharged at 0.5C, and the 1<sup>st</sup> capacity and cycle life for 100<sup>th</sup> cycles were measured, and the results are presented in Table 11. In addition, internal resistance of each battery and surface roughness Ra of each positive electrode are shown in Table 11.

Table 11

	Surface roughness (Ra)	Internal resistance ( $\Omega$ )	1 <sup>st</sup> capacity (mAh/g)	Cycle life for 100th cycles (%)
Comparative Example 1	3.0	9.8	1200	60
Example 12	2.9	9.8	1050	65
Example 13	2.6	9.6	1122	70
Example 14	2.5	9.5	1233	86
Example 15	2.4	9.6	1252	87
Example 16	2.3	9.5	1288	91

It is shown in Table 11 that Examples 12 to 16 using  $\text{ZrO}_2$  exhibited lower surface roughness than Comparative Example 1 without  $\text{ZrO}_2$ . Such a lower surface roughness renders a decrease in interfacial resistance, causing a decrease in internal resistance of the battery and increases in 1<sup>st</sup> capacity and cycle life.

Examples 17 to 21: Test for battery performance according to amount of added  $\text{ZrO}_2$

Positive electrodes for a lithium-sulfur cell were produced by the same procedure as in Example 1, except that the amounts of  $\text{ZrO}_2$  with a particle size D (v, 50%) of 10 nm were varied as set forth in the following Table 12. The surface roughness of each positive electrode was measured, and the results are shown in Table 12. The result according to Example 16 with a particle size D (v, 50%) of 10 nm is also shown in Table 12.

Table 12

	Composition of positive electrode (weight ratio)	Surface roughness (Ra)
Comparative Example 1	Sulfur/Conductive material/Binder (60/20/20)	3.0
Example 17	Sulfur/Conductive material/Binder/ $\text{ZrO}_2$ (A: D(v, 50%)=10nm) (60/20/20/2)	2.9
Example 18	Sulfur/Conductive material/Binder/ $\text{ZrO}_2$ (A: D(v, 50%)=10nm) (60/20/20/5)	2.8
Example 16	Sulfur/Conductive material/Binder/ $\text{ZrO}_2$ (A: D(v, 50%)=10nm) (60/20/20/10)	2.5
Example 19	Sulfur/Conductive material/Binder/ $\text{ZrO}_2$ (A: D(v, 50%)=10nm) (60/20/20/15)	2.4
Example 20	Sulfur/Conductive material/Binder/ $\text{ZrO}_2$ (A: D(v, 50%)=10nm) (60/20/20/20)	2.6
Example 21	Sulfur/Conductive material/Binder/ $\text{ZrO}_2$ (A: D(v, 50%)=10nm) (60/20/20/25)	2.5

Table 12 indicates that the same or smaller particle size of  $\text{ZrO}_2$  than the positive active material decreases surface roughness when compared with Comparative Example 1 without  $\text{ZrO}_2$ .

#### < Experiment 10: Measurement of Battery Performance >

Using positive electrodes according to each of Examples 16 to 21, pouch-type lithium sulfur cells were fabricated by the same procedure as in Experiment 8. The cells were charged at 0.2C and discharged at 0.5C, and the 1<sup>st</sup> capacity and cycle life for 100<sup>th</sup> cycles were measured, and the results are presented in Table 13. In addition, internal resistance of each battery and surface roughness Ra of each positive electrode are shown in Table 13.

Table 13

	Surface roughness (Ra)	Internal resistance ( $\Omega$ )	1 <sup>st</sup> capacity (mAh/g)	Cycle life for 100 <sup>th</sup> cycles (%)
Comparative Example 1	3.0	9.8	1200	60
Example 17	2.9	9.6	1225	71
Example 18	2.7	9.5	1249	87
Example 16	2.3	9.5	1288	91
Example 19	2.4	9.4	1258	85
Example 20	2.5	9.4	1233	81
Example 21	2.5	9.3	1232	74

It is shown in Table 13 that Examples 16 to 21 using  $\text{ZrO}_2$  exhibited lower surface roughness than Comparative Example 1 without  $\text{ZrO}_2$ . Such lower surface roughness renders a decrease in interfacial resistance between the positive electrode and the separator, causing a decrease in internal resistance of the battery. As a result, the 1<sup>st</sup> capacities in Examples 16 to 21 are slightly larger than that in Comparative Example 1, and the cycle life greatly increased by 5 to 20% when compared with Comparative Example 1. This result is believed to come about from the higher ionic conductivity in 5 to 20wt% of  $\text{V}_2\text{O}_5$  even though Examples 16 to 21 have similar surface roughness (See Table 8).

As a result, the  $\text{ZrO}_2$  additive with the critical particle size increases ionic conductivity of the positive electrode and decreases surface roughness, thereby increasing capacity from 1200mAh to 1288mAh, and improving cycle life from 60% to 91%.

#### Example 22

A  $\text{TiS}_2$  additive with a particle size D (v, 50%) of 75,000 nm, an elemental sulfur ( $\text{S}_8$ ) positive active material, a carbon conductive material and a polyethyleneoxide binder were mixed in an acetonitrile solvent in the weight ratio of 1 : 6 : 2 : 2 with a ball to prepare a positive

active material slurry. The elemental sulfur ( $S_8$ ) was obtained from pulverization with a zirconia ball in an isopropylalcohol solvent and drying, and it had a particle size D (v, 50%) of 5,000 nm.

The positive active material slurry was coated on a carbon-coated Al current collector to produce a positive electrode for a lithium-sulfur battery.

#### Example 23

$TiS_2$  powder was pulverized in an isopropyl alcohol solvent with a zirconia ball for 1 hour, and the resulting material was dried at 80°C to prepare a  $TiS_2$  additive with a particle size D (v, 50%) of 20,000 nm.

The  $TiS_2$  additive, an elemental sulfur ( $S_8$ ) positive active material, a carbon conductive material, and a polyethyleneoxide binder were mixed in an acetonitrile solvent in the weight ratio of 1 : 6 : 2 : 2 with a ball to prepare a positive active material slurry. The elemental sulfur ( $S_8$ ) was obtained from pulverization with a zirconia ball in an isopropylalcohol solvent and drying, and it had a particle size D (v, 50%) of 5,000 nm.

The positive active material slurry was coated on a carbon-coated Al current collector to produce a positive electrode for a lithium-sulfur battery.

#### Example 24

A positive electrode was produced by the same procedure as in Example 23, except that the pulverization step was performed for 3 hours to prepare a  $TiS_2$  additive with a particle size D (v, 50%) of 5,000 nm.

#### Example 25

A positive electrode was produced by the same procedure as in Example 23, except that the pulverization step was performed for 6 hours to prepare a  $TiS_2$  additive with a particle size D (v, 50%) of 1,000 nm.

#### Example 26

A positive electrode was produced by the same procedure as in Example 23 except that a pulverization step was performed for 12 hours to prepare a  $TiS_2$  additive with a particle size D (v, 50%) of 100 nm.

#### Example 27

A positive electrode was produced by the same procedure as in Example 23, except that the pulverization step was performed for 24 hours to prepare a  $TiS_2$  additive with a particle size D (v, 50%) of 10 nm.

< Experiment 11: Measurement of ionic conductivity according to a particle size D (v, 50%) of  $TiS_2$ >



Polyethylene oxide with a molecular weight of 5,000,000 was dissolved in acetonitrile, and a  $\text{LiN}(\text{SO}_2\text{CF}_3)_2$  lithium salt was added thereto and dissolved therein until the mole ratio of ethylene oxide to Li reached 10 : 1. The  $\text{TiS}_2$  additives according to Examples 20 to 25 were added to the resulting solution in an amount of 10 wt% based on the total amount of polyethylene oxide and the  $\text{LiN}(\text{SO}_2\text{CF}_3)_2$  lithium salt, and they were shaken for 2 hours. The resulting solutions were cast to form polymer films, and the ionic conductivity of each was measured. The results are presented in Table 14.

Table 14

Type of polymer film	Ionic conductivity (S/cm) (room temperature)
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2$	$9.6 \times 10^{-7}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(\text{D(v, 50\%)}=75,000\text{nm})$	$1.1 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(\text{D(v, 50\%)}=20,000\text{nm})$	$2.7 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(\text{D(v, 50\%)}=5,000\text{nm})$	$5.0 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(\text{D(v, 50\%)}=1,000\text{nm})$	$8.9 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(\text{D(v, 50\%)}=100\text{nm})$	$3.5 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(\text{D(v, 50\%)}=10\text{nm})$	$5.1 \times 10^{-5}$

As shown in Table 14, the addition of  $\text{TiS}_2$  increases ionic conductivity, and such an increase in ionic conductivity is improved as the particle size of  $\text{TiS}_2$  becomes smaller. This is believed to be because an inorganic additive such as  $\text{TiS}_2$  prevents crystallization of the polymer.

The increases in ionic conductivity according to the amount of  $\text{TiS}_2$  were measured.  $\text{TiS}_2$  with a particle size D (v, 50%) of 10 nm was used. The results are presented in Table 15.

Table 15

Type of polymer film	Ionic conductivity (S/cm)(room temperature)
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(2 \text{ wt\%})$	$1.2 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(5 \text{ wt\%})$	$4.4 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(10 \text{ wt\%})$	$5.1 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(15 \text{ wt\%})$	$3.2 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(20 \text{ wt\%})$	$2.2 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-TiS}_2(25 \text{ wt\%})$	$8.6 \times 10^{-6}$

It is evident from Table 15 that an amount of 5 to 15 wt% of  $\text{TiS}_2$  exhibited higher ionic conductivity.

These two test results indicate that  $\text{TiS}_2$  increases ionic conductivity, and as the particle size of  $\text{TiS}_2$  decreases, ionic conductivity increases.

#### < Experiment 12: Measurement of surface roughness >

The surface roughness Ra of each positive electrode according to Examples 22 to 27 and Comparative Example 1 were measured, and the results are shown in Table 16.

Table 16

	Composition of the positive electrode (weight ratio)	Surface roughness (Ra)
Comparative Example 1	Sulfur/Conductive material/Binder (6/2/2)	3.0
Example 22	Sulfur/Conductive material/Binder/ $\text{TiS}_2$ (A: D(v, 50%)=75,000nm) (6/2/2/1)	7.6
Example 23	Sulfur/Conductive material/Binder/ $\text{TiS}_2$ (A: D(v, 50%)=20,000nm) (6/2/2/1)	5.4
Example 24	Sulfur/Conductive material/Binder/ $\text{TiS}_2$ (A: D(v, 50%)=5,000nm) (6/2/2/1)	3.0
Example 25	Sulfur/Conductive material/Binder/ $\text{TiS}_2$ (A: D(v, 50%)=1,000nm) (6/2/2/1)	2.6
Example 26	Sulfur/Conductive material/Binder / $\text{TiS}_2$ (A: D(v, 50%)=100nm) (6/2/2/1)	2.4
Example 27	Sulfur/Conductive material/Binder / $\text{TiS}_2$ (A: D(v, 50%)=10nm) (6/2/2/1)	2.3

In Table 16, Ra indicates the arithmetic mean of each peak (between highest and lowest peaks), and the lower Ra indicates a more uniform surface. It is evident from Table 16 that Examples 24 to 27 exhibited improved surface roughness.

#### < Experiment 13: Measurement of battery performance >

Using positive electrodes according to each of Examples 22 to 27 and Comparative Example 1, pouch-type lithium-sulfur cells were fabricated by the following procedure. The size of each positive electrode was 25mm X 50mm. The cells were test cells with a higher capacity than a coin cell (capacity of 3-5mAh).

A tab was welded to each positive electrode, and the resulting positive electrode was placed in a pouch. On the positive electrode, a separator was positioned. A tab-attached lithium foil was placed on the separator, and the pouch was sealed except for an electrolyte inserting hole. 1M  $\text{LiN}(\text{SO}_2\text{CF}_3)_2$  in dimethoxyethane/1,3-dioxolane (80/20 volume ratio) was injected into the pouch.

The cells were charged at 0.2C and discharged at 0.5C, the 1<sup>st</sup> capacity and cycle life for 100<sup>th</sup> cycles were measured, and the results are presented in Table 17. In addition, internal resistance of the batteries and surface roughness Ra of the positive electrodes are shown in Table 17.

Table 17

	Surface roughness (Ra)	Internal resistance ( $\Omega$ )	1 <sup>st</sup> capacity (mAh/g)	Cycle life for 100th cycles (%)
Comparative Example 1	3.0	9.8	1200	60
Example 22	7.6	12.3	1175	63
Example 23	5.4	10.5	1185	74
Example 24	3.0	9.8	1211	73
Example 25	2.6	9.5	1246	83
Example 26	2.4	9.6	1254	88
Example 27	2.3	9.4	1279	90

It is shown in Table 17 that Examples 22 to 27 using TiS<sub>2</sub> exhibited lower surface roughness than Comparative Example 1 without TiS<sub>2</sub>. Such a lower surface roughness renders a decrease in interfacial resistance, causing a decrease in internal resistance of the battery and an increase in 1<sup>st</sup> capacity and cycle life.

Examples 28 to 32: Test for battery performance according to amount of added TiS<sub>2</sub>

Positive electrodes for a lithium-sulfur cell were produced by the same procedure as in Example 22, except that amounts of TiS<sub>2</sub> with a particle size D (v, 50%) of 10 nm were varied as set forth in the following Table 18. The surface roughness of each positive electrode was measured, and the results are shown in Table 18. The result according to Example 27 with a particle size D (v, 50%) of 10 nm is also shown in Table 18.

Table 18

	Composition of positive electrode (weight ratio)	Surface roughness (Ra)
Comparative Example 1	Sulfur/Conductive material/Binder (60/20/20)	3.0
Example 28	Sulfur/Conductive material/Binder/TiS <sub>2</sub> (A: D(v, 50%)=10nm) (60/20/20/2)	2.9
Example 29	Sulfur/Conductive material/Binder/TiS <sub>2</sub> (A: D(v, 50%)=10nm) (60/20/20/5)	2.7
Example 27	Sulfur/Conductive material/Binder/TiS <sub>2</sub> (A: D(v, 50%)=10nm) (60/20/20/10)	2.3
Example 30	Sulfur/Conductive material/Binder/TiS <sub>2</sub> (A: D(v, 50%)=10nm) (60/20/20/15)	2.2
Example 31	Sulfur/Conductive material/Binder/TiS <sub>2</sub> (A: D(v, 50%)=10nm) (60/20/20/20)	2.3
Example 32	Sulfur/Conductive material/Binder/TiS <sub>2</sub> (A: D(v, 50%)=10nm) (60/20/20/25)	2.2

Table 18 indicates that a particle size of TiS<sub>2</sub> less than or equal to that of the positive active material decreases surface roughness when compared with Comparative Example 1 without TiS<sub>2</sub>.

#### < Experiment 14: Measurement of Battery Performance >

Using positive electrodes according to each of Examples 27 to 32, pouch-type lithium sulfur cells were fabricated by the same procedure as in Experiment 13. The cells were charged at 0.2C and discharged at 0.5C, the 1<sup>st</sup> capacity and cycle life for 100<sup>th</sup> cycles were measured, and the results are presented in Table 19. In addition, internal resistance of each battery and surface roughness Ra of each positive electrode are shown in Table 19.

Table 19

	Surface roughness (Ra)	Internal resistance (Ω)	1 <sup>st</sup> capacity (mAh/g)	Cycle life for 100 <sup>th</sup> cycles (%)
Comparative Example 1	3.0	9.8	1200	60
Example 28	2.9	9.7	1228	70
Example 29	2.7	9.6	1244	85
Example 27	2.3	9.4	1279	90
Example 30	2.2	9.3	1250	88
Example 31	2.3	9.4	1237	82
Example 32	2.2	9.3	1229	72

It is shown in Table 19 that Examples 27 to 31 using TiS<sub>2</sub> exhibited lower surface roughness than Comparative Example 1 without TiS<sub>2</sub>. Such a lower surface roughness

renders a decrease in interfacial resistance between the positive electrode and the separator, causing a decrease in internal resistance of the battery. As a result, the 1<sup>st</sup> capacities in Examples 16 to 21 are slightly larger than that of Comparative Example 1, and the cycle life greatly increased by 5 to 20% when compared with Comparative Example 1. This result is believed to come about because of the higher ionic conductivity with 5 to 20wt% of TiS<sub>2</sub>, even though Examples 27 to 32 have similar surface roughness (See Table 15).

As a result, the TiS<sub>2</sub> additive with the critical particle size increases ionic conductivity of the positive electrode and decreases surface roughness, thereby increasing capacity from 1200mAh to 1279mAh, and improving cycle life from 60% to 90%.

#### Example 1

Al<sub>2</sub>O<sub>3</sub> powder was pulverized in an isopropyl alcohol solvent with a zirconia ball for 1 hour, and the resulting material was dried at 80°C to prepare an Al<sub>2</sub>O<sub>3</sub> additive with a particle size D (v, 50%) of 35,000 nm.

The Al<sub>2</sub>O<sub>3</sub> additive, an elemental sulfur (S<sub>8</sub>) positive active material, a carbon conductive material, and a polyethyleneoxide binder were mixed in an acetonitrile solvent in the weight ratio of 1 : 6 : 2 : 2 with a ball to prepare a positive active material slurry. The elemental sulfur (S<sub>8</sub>) was obtained from pulverization with a zirconia ball in isopropylalcohol solvent, and drying, and it had a particle size D (v, 50%) of 5,000 nm.

The positive active material slurry was coated on a carbon-coated Al current collector to produce a positive electrode for a lithium-sulfur battery.

#### Example 2

A positive electrode was produced by the same procedure as in Example 1, except that the pulverization step was performed for 6 hours to prepare an Al<sub>2</sub>O<sub>3</sub> additive with a particle size D (v, 50%) of 200 nm.

#### Example 3

A positive electrode was produced by the same procedure as in Example 1, except that the pulverization step was performed for 12 hours to prepare an Al<sub>2</sub>O<sub>3</sub> additive with a particle size D (v, 50%) of 50 nm.

#### Example 4

A positive electrode was produced by the same procedure as in Example 1, except that the pulverization step was performed for 24 hours to prepare an Al<sub>2</sub>O<sub>3</sub> additive with a particle size D (v, 50%) of 6 nm.

#### Example 5

A positive electrode was produced by the same procedure as in Example 1, except that the pulverization step was performed for 48 hours to prepare an  $\text{Al}_2\text{O}_3$  additive with a particle size D (v, 50%) of 5.8 nm.

#### Comparative Example 1

A positive electrode was produced by the same procedure as in Example 1, except that an  $\text{Al}_2\text{O}_3$  additive with a particle size D (v, 50%) of 109,000 nm without a pulverization step was used.

#### Comparative Example 2

A positive electrode was produced by the same procedure as in Example 1, except that an  $\text{Al}_2\text{O}_3$  additive was not used.

< Experiment 1: Measurement of ionic conductivity according to a particle size D (v, 50%) of  $\text{Al}_2\text{O}_3$  >

Polyethylene oxide with a molecular weight of 5,000,000 was dissolved in acetonitrile, and a  $\text{LiN}(\text{SO}_2\text{CF}_3)_2$  lithium salt was added thereto and dissolved therein until the mole ratio of ethylene oxide to Li reached 10 : 1. An  $\text{Al}_2\text{O}_3$  additive according to one of Examples 1 to 4 and Comparative Example 1 was added to the resulting solution in the amount of 10 wt% of the total amount of polyethylene oxide and the  $\text{LiN}(\text{SO}_2\text{CF}_3)_2$  lithium salt, and they were shaken for 2 hours. The resulting solution was cast to form a polymer film, and the ionic conductivity thereof was measured. The results are presented in Table 1.

Table 1

Type of polymer film	Ionic conductivity (S/cm) (room temperature)
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2$	$9.6 \times 10^{-7}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-Al}_2\text{O}_3(\text{D(v, 50\%)}=109,000\text{nm})$	$1.5 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-Al}_2\text{O}_3(\text{D(v, 50\%)}=35,000\text{nm})$	$2.7 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-Al}_2\text{O}_3(\text{D(v, 50\%)}=200\text{nm})$	$7.6 \times 10^{-6}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-Al}_2\text{O}_3(\text{D(v, 50\%)}=50\text{nm})$	$4.2 \times 10^{-5}$
$\text{PEO}_{10}\text{-LiN}(\text{SO}_2\text{CF}_3)_2\text{-Al}_2\text{O}_3(\text{D(v, 50\%)}=6\text{nm})$	$5.0 \times 10^{-5}$

As shown in Table 1, the addition of  $\text{Al}_2\text{O}_3$  increases ionic conductivity, and such an increase in ionic conductivity is improved as the particle size of  $\text{Al}_2\text{O}_3$  decreases. This is

believed to be because the inorganic additive such as  $\text{Al}_2\text{O}_3$  prevents the crystallization of the polymer.

The increases in ionic conductivity according to the amount of  $\text{Al}_2\text{O}_3$  were measured.  $\text{Al}_2\text{O}_3$  with a particle size D (v, 50%) of 6 nm was used. The results are presented in Table 2.

Table 2

Type of polymer film	Ionic conductivity (S/cm)(room temperature)
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> (2 wt%)	$1.2 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> (5 wt%)	$4.1 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> (10 wt%)	$5.0 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> (15 wt%)	$3.8 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> (20 wt%)	$2.2 \times 10^{-5}$
PEO <sub>10</sub> -LiN(SO <sub>2</sub> CF <sub>3</sub> ) <sub>2</sub> -Al <sub>2</sub> O <sub>3</sub> (25 wt%)	$7.0 \times 10^{-6}$

It is evident from Table 2 that an amount of 5 to 15 wt% of  $\text{Al}_2\text{O}_3$  exhibited higher ionic conductivity.

These two test results indicate that  $\text{Al}_2\text{O}_3$  increases ionic conductivity and as the particle size of  $\text{Al}_2\text{O}_3$  decreases, ionic conductivity increases.

< Experiment 2: Measurement of surface roughness>

The surface roughness Ra of each positive electrode according to Examples 1 to 4 and Comparative Examples 1 to 2 was measured, and the results are shown in Table 3.

Table 3

	Composition of the positive electrode (weight ratio)	Surface roughness (Ra)
Comparative Example 1	Sulfur/Conductive material/Binder (6/2/2)	3.0
Comparative Example 2	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (D(v, 50%)=109,000nm) (6/2/2/1)	11.5
Example 1	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (D(v, 50%)=35,000nm) (6/2/2/1)	6.2
Example 35	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (D(v, 50%)=200nm) (6/2/2/1)	2.8
Example 36	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (D(v, 50%)=50nm) (6/2/2/1)	2.6
Example 37	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (D(v, 50%)=6nm) (6/2/2/1)	2.3

In Table 3, Ra indicates the arithmetic mean of each peak (between highest and lowest peaks), and the lower Ra indicates a more uniform surface. It is evident from Table 3 that

Comparative Examples 1 and Example 1 with a particle size of  $\text{Al}_2\text{O}_3$  larger than the sulfur active material (5,000nm) exhibited poorer uniformity (unevenness and roughness) than Comparative Example 2 without  $\text{Al}_2\text{O}_3$ , and Examples 2 to 4 with a smaller or the same particle size of  $\text{Al}_2\text{O}_3$  as the sulfur active material exhibited the same or better uniformity.

#### < Experiment 3: Measurement of battery performance>

Using positive electrodes according to each of Examples 1 to 4 and Comparative Examples 1 and 2, pouch-type lithium-sulfur cells were fabricated by the following procedure. The size of each positive electrode was 25mm X 50mm, and the cells were test cells with a higher capacity than a coin cell (capacity of 3-5mAh).

A tab was welded to each positive electrode, and the resulting positive electrode was placed in a pouch. On the positive electrode, a separator was positioned. A tab-attached lithium foil was placed on the separator, and the pouch was sealed except for an electrolyte inserting hole. 1M  $\text{LiN}(\text{SO}_2\text{CF}_3)_2$  in dimethoxyethane/1,3-dioxolane (80/20 volume ratio) was injected into the pouch.

The cells were charged at 0.2C and discharged at 0.5C, and the 1<sup>st</sup> capacity and cycle life for the 100<sup>th</sup> cycles were measured, and the results are presented in Table 4. In addition, internal resistance of each battery and surface roughness Ra of each positive electrode are shown in Table 4.

Table 4

	Surface roughness (Ra)	Internal resistance ( $\Omega$ )	1 <sup>st</sup> capacity (mAh/g)	Cycle life for 100th cycles (%)
Comparative Example 2	3.0	9.8	1200	60
Comparative Example 1	11.5	14.5	1188	62
Example1	6.2	11.5	1165	65
Example 2	2.8	9.5	1236	85
Example 3	2.6	9.6	1254	89
Example 4	2.3	9.4	1289	91

It is shown in Table 4 that Examples 1 to 4 using  $\text{Al}_2\text{O}_3$  with the same or smaller particle size than the sulfur positive active material (5,000 nm) exhibited lower surface roughness than Comparative Example 2 without  $\text{Al}_2\text{O}_3$ , and such a lower surface roughness renders a decrease in interfacial resistance, causing a decrease in internal resistance of the battery and an increase in 1<sup>st</sup> capacity and cycle life.



On the other hand, Comparative Example 1 using  $\text{Al}_2\text{O}_3$  with a particle size larger than the sulfur positive active material (5,000 nm) exhibited more surface roughness than Comparative Example 2 without  $\text{Al}_2\text{O}_3$ , which results in an increase in internal resistance and a decrease in capacity and cycle life.

Examples 4, 6 to 10 and Comparative Example 2: Test for battery performance according to amount of added  $\text{Al}_2\text{O}_3$

Positive electrodes were produced by the same procedure as in Example 1, except that amounts of  $\text{Al}_2\text{O}_3$  with a particle size D (v, 50%) of 6 nm were varied as set forth in the following Table 5. The surface roughness of each positive electrode was measured, and the results are shown in Table 5.

Table 5

	Composition of positive electrode (weight ratio)	Surface roughness (Ra)
Comparative Example 2	Sulfur/Conductive material/Binder (60/20/20)	3.0
Example 6	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (A: D(v, 50%)=6nm) (60/20/20/2)	2.8
Example 7	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (A: D(v, 50%)=6nm) (60/20/20/5)	2.8
Example 4	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (A: D(v, 50%)=6nm) (60/20/20/10)	2.3
Example 8	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (A: D(v, 50%)=6nm) (60/20/20/15)	2.2
Example 9	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (A: D(v, 50%)=6nm) (60/20/20/20)	2.4
Example 10	Sulfur/Conductive material/Binder/ $\text{Al}_2\text{O}_3$ (A: D(v, 50%)=6nm) (60/20/20/25)	2.3

Table 5 indicates that the same or smaller particle size of  $\text{Al}_2\text{O}_3$  according to Examples 4, 6 to 10 than the positive active material decreases surface roughness when compared with Comparative Example 1 without  $\text{Al}_2\text{O}_3$ .

#### < Experiment 5: Measurement of Battery Performance >

Using positive electrode according to each of Examples 4, and 6 to 10, and Comparative Example 2, pouch-type lithium sulfur cells were fabricated by the same procedure as in Experiment 4. The cells were charged at 0.2C and discharged at 0.5C, the 1<sup>st</sup> capacity and cycle life for 100<sup>th</sup> cycles were measured, and the results are presented in Table 6. In addition, internal resistance of each battery and surface roughness Ra of each positive electrode are shown in Table 6.

Table 6

	Surface roughness (Ra)	Internal resistance ( $\Omega$ )	1 <sup>st</sup> capacity (mAh/g)	Cycle life for 100 <sup>th</sup> cycles (%)
Comparative Example 2	3.0	9.8	1200	60
Example 6	2.8	9.6	1218	71
Example 7	2.8	9.6	1240	87
Example 4	2.3	9.4	1289	91
Example 8	2.2	9.3	1255	88
Example 9	2.4	9.5	1239	86
Example 10	2.3	9.4	1231	75

It is shown in Table 6 that Examples 4, and 6 to 10 using  $\text{Al}_2\text{O}_3$  with the same or smaller particle size than the sulfur positive active material (5,000 nm) exhibited lower surface roughness than Comparative Example 2 without  $\text{Al}_2\text{O}_3$ , and such a lower surface roughness renders a decrease in interfacial resistance, causing a decrease in internal resistance of the battery. As a result, the 1<sup>st</sup> capacities in Examples are slightly larger than that in Comparative Example 2, and the cycle life greatly increases by 5 to 20% when compared to Comparative Example 1. This result is believed to come about from higher ionic conductivity in 5 to 20wt% of  $\text{Al}_2\text{O}_3$  even though Examples 36 and 38 to 42 have similar surface roughness (See Table 2).  
[Effect of the invention]

As a result, the  $\text{Al}_2\text{O}_3$  additive with the critical particle size increases ionic conductivity of the positive electrode and decreases surface roughness, thereby increasing capacity from 1200mAh to 1289mAh, and improving cycle life from 60% to 91%.

## **WHAT IS CLAIMED IS:**

1. A positive electrode for a lithium-sulfur battery comprising:  
a positive active material selected from the group consisting of elemental sulfur ( $S_8$ ), a sulfur-based compound, and mixtures thereof;  
a conductive material;  
a binder; and  
an  $Al_2O_3$  additive with a particle size D (v, 50%) of 35,000nm or less.
2. The positive electrode of claim 1, wherein the  $Al_2O_3$  additive has a particle size D (v, 50%) of 1 to 3 5,000 nm.
3. The positive electrode of claim 2, wherein the  $Al_2O_3$  additive has a particle size D (v, 50%) of 3 to 10,000 nm.
4. The positive electrode of claim 3, wherein the  $Al_2O_3$  additive has a particle size D (v, 50%) of 5 to 5,000 nm.
5. The positive electrode of claim 1, wherein a surface roughness of the positive electrode, Ra, is 5  $\mu m$  or less.
6. The positive electrode of claim 5, wherein a surface roughness of the positive electrode, Ra, is 0.1 to 5  $\mu m$ .
7. The positive electrode of claim 6, wherein a surface roughness of the positive electrode, Ra, is 0.2 to 4  $\mu m$ .
8. The positive electrode of claim 1, wherein the  $Al_2O_3$  additive is present in an amount of 1 to 50 wt%.
9. The positive electrode of claim 1, wherein the  $Al_2O_3$  additive is present in an amount of 2 to 25 wt%.
10. The positive electrode of claim 1, wherein the  $Al_2O_3$  additive is present in an amount of 3 to 20 wt%.
11. The positive electrode of claim 1, wherein the sulfur-based compound is selected from the group consisting of  $Li_2S_n$ , wherein  $n \geq 1$ ,) organic-sulfur compounds, and carbon-sulfur polymers having the formula  $(C_2S_x)_n$ , where  $x=2.5$  to 50 and  $n \geq 2$ .
12. The positive electrode of claim 1, wherein the positive electrode further comprises a coating layer, the coating layer comprising a polymer, an inorganic material, or a mixture thereof.

13. The positive electrode of claim 12, wherein the coating layer comprises a polymer selected from the group consisting of polyvinylidene fluoride, copolymers of polyvinylidene fluoride and hexafluoropropylene, poly(vinyl acetate), poly(vinyl butyral-co-vinyl alcohol-co-vinyl acetate), poly(methylmethacrylate-co-ethyl acrylate), polyacrylonitrile, polyvinyl chloride-co-vinyl acetate, polyvinyl alcohol, poly(1-vinylpyrrolidone-co-vinyl acetate), cellulose acetate, polyvinyl pyrrolidone, polyacrylate, polymethacrylate, polyolefin, polyurethane, polyvinyl ether, acrylonitrile-butadiene rubber, styrene-butadiene rubber, acrylonitrile-butadiene styrene, a sulfonated styrene/ethylene-butylene/styrene triblock copolymer, polyethylene oxide, and mixtures thereof.

14. The positive electrode of claim 12, wherein the coating layer comprises an inorganic material selected from the group consisting of colloidal silica, amorphous silica, surface-treated silica, colloidal alumina, amorphous alumina, tin oxide, titanium oxide, vanadium oxide, titanium oxide ( $\text{TiS}_2$ ), zirconium oxide ( $\text{ZrO}_2$ ), iron oxide, iron sulfide ( $\text{FeS}$ ), iron titanate ( $\text{FeTiO}_3$ ), barium titanate ( $\text{BaTiO}_3$ ), and mixtures thereof.

15. A lithium sulfur-battery comprising:  
a positive electrode comprising a positive active material selected from the group consisting of elemental sulfur ( $\text{S}_8$ ), sulfur-based compounds, and mixtures thereof, a conductive material, a binder and an  $\text{Al}_2\text{O}_3$  additive with a particle size D (v, 50%) of 35,000nm or less;  
a negative electrode comprising a negative active material selected from the group consisting of a material that is capable of reversibly intercalating or deintercalating lithium ions, a material that reacts with lithium ions to prepare a lithium-included compound, a lithium metal, and a lithium alloy; and  
an electrolyte.

16. The lithium-sulfur battery of claim 15, wherein the  $\text{Al}_2\text{O}_3$  additive has a particle size D (v, 50%) of 1 to 35,000 nm.

17. The lithium-sulfur battery of claim 16, wherein the  $\text{Al}_2\text{O}_3$  additive has a particle size D (v, 50%) of 3 to 10,000 nm.

18. The lithium-sulfur battery of claim 16, wherein the inorganic additive has a particle size D (v, 50%) of 5 to 5,000 nm.

19. The lithium-sulfur battery of claim 15, wherein a surface roughness of the positive electrode, Ra, is 5  $\mu\text{m}$  or less.

20. The lithium-sulfur battery of claim 19, wherein a surface roughness of the positive electrode, Ra, is 0.1 to 5  $\mu\text{m}$ .

21. The lithium-sulfur battery of claim 20, wherein a surface roughness of the positive electrode, Ra, is 0.2 to 4  $\mu\text{m}$ .

22. The lithium-sulfur battery of claim 15, wherein the positive electrode further comprises a coating layer, the coating layer comprising a polymer, an inorganic material or a mixture thereof.

23. The lithium-sulfur battery of claim 22, wherein the coating layer comprises a polymer selected from the group consisting of polyvinylidene fluoride, copolymers of polyvinylidene fluoride and hexafluoropropylene, poly(vinyl acetate), poly(vinyl butyral-co-vinyl alcohol-co-vinyl acetate), poly(methylmethacrylate-co-ethyl acrylate), polyacrylonitrile, polyvinyl chloride-co-vinyl acetate, polyvinyl alcohol, poly(1-vinylpyrrolidone-co-vinyl acetate), cellulose acetate, polyvinyl pyrrolidone, polyacrylate, polymethacrylate, polyolefin, polyurethane, polyvinyl ether, acrylonitrile-butadiene rubber, styrene-butadiene rubber, acrylonitrile-butadiene styrene, a sulfonated styrene/ethylene-butylene/styrene triblock copolymer, polyethylene oxide, and mixtures thereof.

24. The lithium-sulfur battery of claim 22, wherein the coating layer comprises an inorganic material selected from the group consisting of colloidal silica, amorphous silica, surface-treated silica, colloidal alumina, amorphous alumina, tin oxide, titanium oxide, vanadium oxide, titanium oxide ( $\text{TiS}_2$ ), zirconium oxide ( $\text{ZrO}_2$ ), iron oxide, iron sulfide ( $\text{FeS}$ ), iron titanate ( $\text{FeTiO}_3$ ), barium titanate ( $\text{BaTiO}_3$ ), and mixtures thereof.